

**Work Order ID 59360**

Wednesday, June 02, 2010 1:16:34 PM



Page 1

Item ID: D350-591-213

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step, Short LH

Start Date: 6/2/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: [Signature] Date: 10-6-02 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3078	A								
DSI 9472	A								
100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy bluefile and type labels as per PPP D350-591-213 CHG003								
110		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut D2622-120 extrusion to 59.75" long as per Dwg D3078 2-Drill extrusion as per Dwg D3078 using Jig DT8680 for rivets. 3-Deburr								

10/06/17

10/06/16

10-06-09

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Start Date: 6/2/2010 Start Qty: 4.00

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Required Date: 6/9/2010 Req'd Qty: 4.00

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		S 10/06/09		(44)			
130  Large Fab Large Fab	Large Fab  Memo 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT8681, weld Fwd End Plate as per QSI 004 & Dwg D3072 A/R Aluminum Rod 1/2" x 2 3/8" 3-Grind End Plate flush m11 42 42	0.00  0.00				4	8		
140  QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00  0.00				(7)	80		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 6/9/2010 Req'd Qty: 4.00



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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				<u>4</u> LH			
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00				<u>4</u>	<u>0</u>		
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				<u>4</u>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 6/9/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  Large Fab	Large Fab	0.00				4	0		
Large Fab	<b>Memo</b> 1- Rivet Leg Assembly as per Dwg D3078. 2-Bevel Aft end for welding 3-Inspect for foreign object as per QSI 024 4-Weld Aft End Plate as per QSI 004 & Dwg D3078 A/R Aluminum Rod <u>M112860</u> 5-Grind End Plate flush	0.00							
210  QC	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
Quality Control	<b>Memo</b>	0.00							
220  QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	<b>Memo</b>	0.00							

H 10.06.11

(4) PD 10.06.14

S 10.06.14

(4) LH

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Required Date: 6/9/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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230



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

4/2/10 BR 10-6-14

240



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

Memo

0.00

START TIME: 1:30pm  
OVEN TEMPERATURE: 320°C  
FINISH TIME: 2:00pm

⇒ 10/06/14

4/2/10

250



HandFinish

Hand Finishing

Wing Walk as per dwg QSI005 4.4 Batch 114432

0.00

Memo

0.00

4/2/10 BR 10-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 6/2/2010 Start Qty: 4.00

Required Date: 6/9/2010 Req'd Qty: 4.00

Reference:

Cust Item ID:





Customer:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00					10	06	15 (4)
270  Packaging Packaging	Pick Kit  Memo	0.00  0.00					10-6-17		SL 2/1
280  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00  0.00							(+4 HL)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Start Date: 6/2/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290	Packaging	0.00							
	Packaging								
	Packaging								
	Memo	0.00							
	Identify and pack for shipping as per PPP D350-591-213								
	Location: _____								
	PPP Rev: <u>fe</u>								
300	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								
	Memo	0.00							

10/6/10 (4)

10/06/21

MF

10-6-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 1

Work Order ID: 59360

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC  
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D  
 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 4.00

Required Qty: 4.00

D2622-120C

Manufactured No

110

Each

30.0000

0.5

2



Step Extrusion

Location

Loc Qty

Loc Code

WA

30

55214

30

D3067-1

Manufactured No

130

Each

63.0000

1

4



End Plate

Location

Loc Qty

Loc Code

WA

63

57926

63

D3063-1

Manufactured No

130

Each

12.0000

1

4



Support

Location

Loc Qty

Loc Code

WA

12

51237

12

MS20600-AD4W4

Purchased No

180

Each

439.0000

16

64



Rivets

Location

Loc Qty

Loc Code

ST309

66

114761

66

ST321

373

113368

62

114181

11

114718

300

2  
R10.06.09

2  
4  
R10.06.09

4  
4  
R10.06.09

4  
64  
R10.06.11

64

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 59360



Parent Item: D350-591-213



Parent Item Name: Heli-Access-Step, Short LH

Start Date: 6/2/2010

Required Date: 6/9/2010

Comments:

IPP Rev:B 05.10.14 Modified step 10 KJ/EC  
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
 IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D  
 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM

Start Qty: 4.00

Required Qty: 4.00

D3066-1	Manufactured	No	180	Each	137.0000	2	8
Spacer							

Location	Loc Qty	Loc Code
WA	137	
57920	37	
58540	100	

5  
3  
4

PL 10.06.11

D3065-041	Manufactured	No	180	Each	44.0000	1	4
Step Leg Assembly Hi							

Location	Loc Qty	Loc Code
WA	44	
58160	4	
58536	40	

4  
4

PL 10.06.11

D3067-1	Manufactured	No	200	Each	63.0000	1	4
End Plate							

Location	Loc Qty	Loc Code
WA	63	
57926	63	

4  
8

PL 10.06.11

AN3-35A	Purchased	No	270	Each	57.0000	2	8
Bolt							

Location	Loc Qty	Loc Code
ST353	57	
114382	27	
114784	30	

3  
3

10.6.19 SP 2/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 59360

Parent Item: D350-591-213

Parent Item Name: Heli-Access-Step, Short LH

Comments: IPP Rev:B 05.10.14 Modified step 10 KJ/EC  
 IPP Rev:C 06-06-19 Added D2732-030 AS PER DS19294 JLM  
 IPP Rev:C 06-06-27 Revised as per DS19340 JLM IPP Rev:D  
 10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 4.00

Required Qty: 4.00

D2856-400 Manufactured No 270 f 250.5088 0.6 2.4  
 Abraison Strip

## Location

## Loc Qty

## Loc Code

ST403

250.5088

50593

43.4568

56626

207.052

cut qty of 1 at 4.00" X 7.20" as per dwg (D2856-400-720)

AN4-11A Purchased No 270 Each 349.0000 6 24

Bolt

## Location

## Loc Qty

## Loc Code

ST357

349

110382

349

AN960JD416, NAS1149D0463J Purchased No 270 Each 0.0000 12 148

Washer

D2230-1 Manufactured No 270 Each 85.0000 2 8

Lug

## Location

## Loc Qty

## Loc Code

ST476

85

51566

4

54755

5

57828

76

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D  
10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 4.00

Required Qty: 4.00

MS21042L3.

Purchased

No

270

Each

3,562.000

- 2

18



Nut



10-6-17 SP

## Location

## Loc Qty

## Loc Code

ST300

3562

113537

20

113644

42

114523

1000

114718

500

114784

2000

2

AN4-13A

Purchased

No

270

Each

207.0000

- 4

16



Bolt



1114941 10-6-17 SP

## Location

## Loc Qty

## Loc Code

ST351

-8

114523

-8

ST357

215

114752

215

12

D2732

Manufactured

No

270

f

388.8000

1

4.210526



Rubber Extrusion



10-6-17 SP

## Location

## Loc Qty

## Loc Code

ST412

388.8

56516

388.8

cut qty of 4 at 3.00" as per dwg(D2732-030)

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Shop Packet Print

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IPP Rev:C 06-06-19 Added D2732-030 AS PER DSI9294 JLM  
IPP Rev:C 06-06-27 Revised as per DSI9340 JLM IPP Rev:D  
10.03.17 incorporate seq 180 to 200 remove qc5 DD verified by:JLM

Start Date: 6/2/2010

Required Date: 6/9/2010

Start Qty: 4.00

Required Qty: 4.00

D2230-3 Manufactured No 270 Each 13.0000 2 18  
Lug 1359115 10-6-178

Location Loc Qty Loc Code

ST476 13  
57827 13

AN960JD10 NAS1149D0363J Purchased No 270 Each 0.0000 4 16  
Washer 1114884 10-6-178

MS21042L4 Purchased No 270 Each 4,091.000 6 24  
Nut 10-6-17 5

Location Loc Qty Loc Code

ST139 2  
111827 2  
ST300 4089  
113422 76  
114523 1005  
114718 1000  
114784 2000  
9063 8

AN4-16A Purchased No 270 Each 145.0000 4 16  
Bolt 10-6-17 2140

Location Loc Qty Loc Code

ST358 145  
114330 45  
114523 100

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. <b>D3078</b>	REV. A SHEET 1 OF 2
DATE <b>02.09.11</b>		TITLE <b>STEP ASSEMBLY, HI SHORT</b> SCALE NTS	
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.20 *#*

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WITHOUT NOTICE  
WORK ORDER  
NO. *59360*  
*BJ10-6-02*

Part No.	Description	QTY -041	QTY -042
D3078-041	Step Assembly, High Short (LH)	X	
D3078-042	Step Assembly, High Short (RH)		X
D2622-60	STEP EXTRUSION	1	1
D3063-1	SUPPORT	1	1
D3065-041	LEG ASSEMBLY	1	1
D3066-1	SPACER	2	2
D3067-1	END PLATE	2	2
MS20600AD4W4	RIVET	16	16

**GENERAL NOTES:**

- 1) -041 SHOWN, FOR -042 INSTALL D3063-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

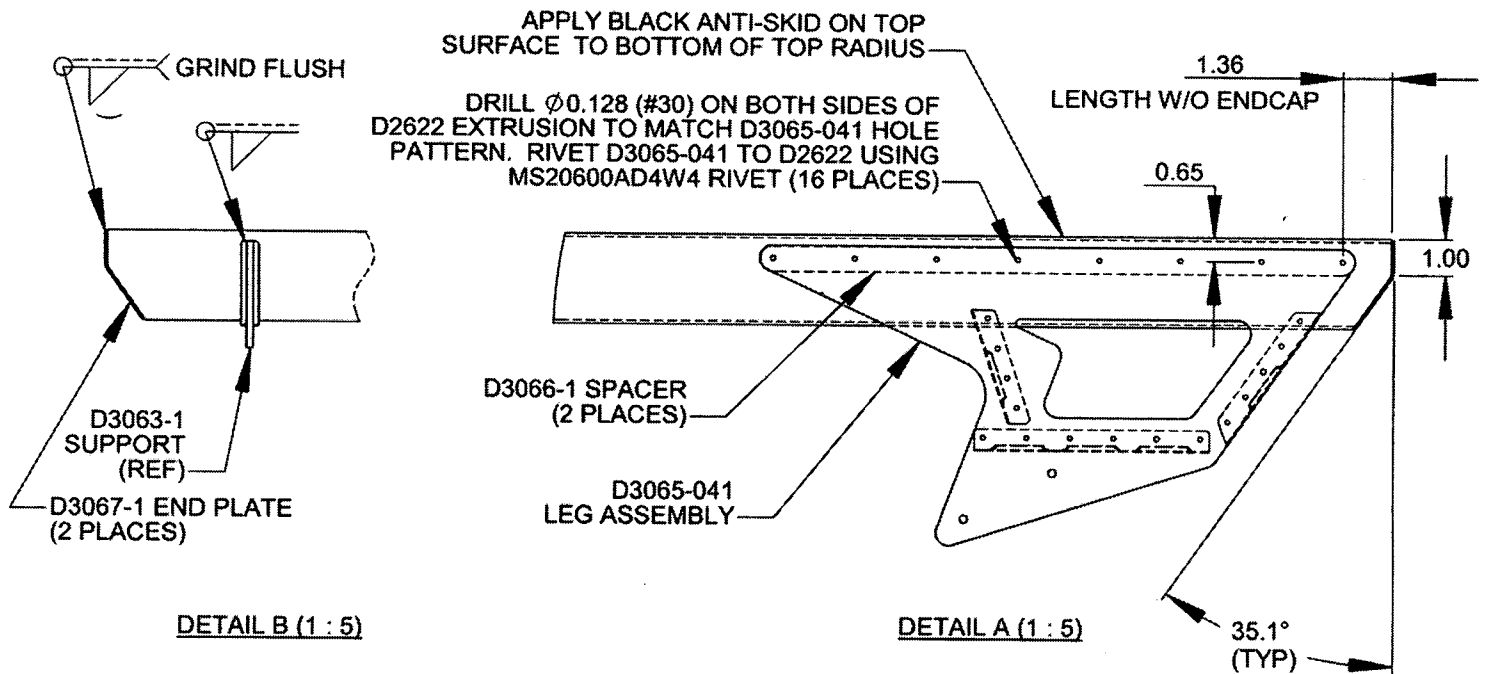
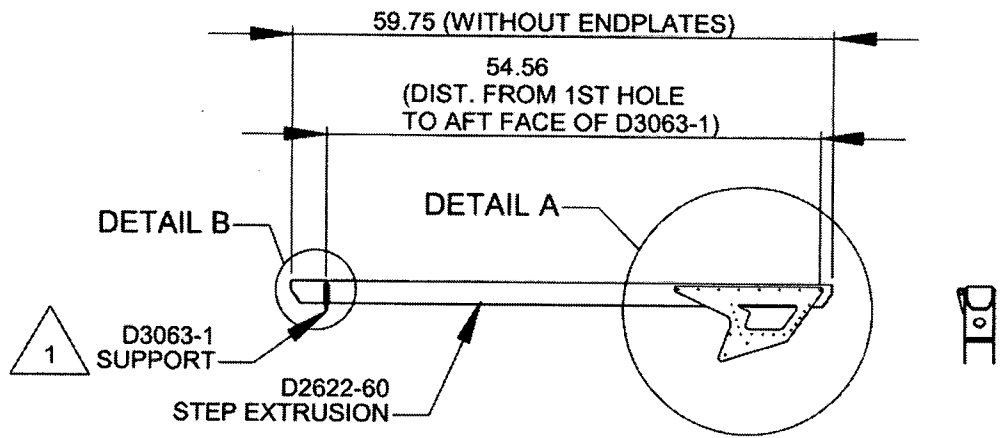
**NOTE:** Date & initial all entries

**DART**



DESIGN	GP	DRAWN BY	GP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA
CHECKED	GP	APPROVED	GP	DRAWING NO. <b>D3078</b>
DATE	02.09.11	TITLE	STEP ASSEMBLY, HI SHORT	REV. A SHEET 2 OF 2
		SCALE	1:20	

RELEASED  
02.09.2004



w/o 59360

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

REFERENCE ONLY

DART AEROSPACE LTD.

D350-591  
Page 23 of 23

Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
	X							D350-591-212	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
		X						D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
			X					D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
				X				D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
					X			D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
						X		D350-591-311	<i>Heli-Access-Step</i> ™, Long Step – High Skid, LH
							X	D350-591-312	<i>Heli-Access-Step</i> ™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	*DSI 9410-011	STEP MODIFICATION KIT

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: G  
Date: 08.10.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART SERVICE INSTRUCTION**

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-213/-214/-215/-216 steps, customers have the option of installing D2732-030 cushion under the clamps to accommodate varying cross-tube diameters and to improve fit, as indicated in Installation Instructions D350-591. This Service Instruction adds longer AN4-16A bolts to the parts list to allow installation of these cushions. See Figure 1 on sheet 2 of this service instruction for reference. Installation of the D2856-400-720 Abrasion Strips per Installation Instructions D350-591 is not required when the cushions are installed.

For D350-591-213/-214/-215/-216 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

**ADD:**

Qty -213	Qty -214	Qty -215	Qty -216	Part Number	Description
X				D350-591-213	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-214	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-215	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-216	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
4	4	4	4	AN4-16A	BOLT

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01






APPROVED

BY:   
D. SHEPHERD (DE # 02)

DATE: 09.08.05

CERT. NO.: SH92-6

ISSUE NO.: 11

A	NEW ISSUE	RF	09.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9472	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BOLT ADDITION	NTS
DATE	09.08.05	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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